

Date: Tuesday, 23/12/2008 1:22:24 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HI-STEP LEG ASSEMBLY  
 Job Number : 44293  
 Estimate Number : 10355  
 P.O. Number :  
 This Issue : 23/12/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2582  
 Drawing Number : D2582 REV B  
 Project Number : N/A  
 First Issue : / / Type : SMALL /MED FAB Drawing Revision : B  
 Material :  
 Previous Run : 40087 Due Date : 05/01/2009 Qty: 16 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:F Removed Manufacturing 05-11-07 JLM  
 Est Rev:G Added part # to Sub 06-08-10 JLM  
 Est Rev H New pick list 08.01.11 EC verified  
 by: DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 44293A STEP LEG



Comment: Sub-Component STEP LEG

2 x D2278 Batch

B44293A (31x)

B40087A (10x)

*[Signature]*  
 23/12/08

2.0 44293B STEP SPACER



Comment: Sub-Component STEP SPACER

1 x D2322 Batch

B40087B (5x)

B44293B (11x)

*[Signature]*  
 23/12/08

3.0 44293C STEP SPACER



Comment: Sub-Component STEP SPACER

1 x D2279 Batch

B37452C

*[Signature]*  
 23/12/08

4.0 44293D STEP SPACER



Comment: Sub-Component STEP SPACER

1 x D3720-1 Batch

B40087D (5x)

B44293 (11x)

*[Signature]*  
 23/12/08

5.0 44293E STEP SPACER



Comment: Sub-Component STEP SPACER

1 x D3720-2 Batch

B40087E (6x)

B44293 (10x)

*[Signature]*  
 23/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 23/12/2008 1:22:24 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 44293

Part Number: D2582

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 22.0000 Each(s)/Unit Total : 352.0000 Each(s)

Pick:

Qty Part Number Description Batch

22 MS20470AD4-4 Rivet

M109631

09/01/26

7.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 4.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS20470AD4-5 Rivet

M106918 (27A)

M109031 (37)

09/01/26

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2582 and

09/01/26 (16)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/26 (16)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SHD 09-01-26 (16)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/27

Job Completion



u 09-01-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

D2278 STEP LEG  
(2 PLACES)

MS20470AD4-4 RIVET  
(5 PLACES PER SIDE)  
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2279 STEP SPACER

D2322 STEP SPACER

MS20470AD4-4 RIVET  
(6 PLACES PER SIDE)  
(INSTALL FROM OUTSIDE OF ASSEMBLY)

### D2582 STEP LEG ASSEMBLY

MS20470AD4-5 RIVET  
(2 PLACES)

MS20470AD4-5 RIVET  
(2 PLACES)

D3720-2 STEP SPACER

D3720-1 STEP SPACER

C'SINK ON INSIDE  
GRIND RIVET FLUSH TO  
SURFACE AS REQUIRED  
(BOTH SIDES)

### D2582 STEP LEG ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2582	STEP LEG ASSEMBLY
2	D2278	STEP LEG
1	D2279	STEP SPACER
1	D2322	STEP SPACER
1	D3720-1	STEP SPACER
1	D3720-2	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

#### NOTES:

- 1) FINISH: NONE
- 2) IDENTIFICATION: IDENTIFY WITH DART P/N "D2582" USING FINE POINT PERMANENT INK MARKER WHERE INDICATED
- 3) WEIGHT: 1.25 lbs

RELEASED  
05-01-10

B	REPLACE D2280 SPACERS WITH D3720-1/2 SPACERS REFERENCE NCR 263 UPDATE DRAWING FORMAT	PH	07.12.27
A	NEW ISSUE	CP	01.10.05
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO. D2582	
CHECKED	LE	REV. B SHEET 1 OF 1	
MFG. APPR.	LE	TITLE SCALE	
APPROVED	LE	STEP LEG ASSEMBLY NTS	
DE APPR.	LE	DATE 07.12.27	
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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